

Work Order ID 143878

March 24, 2016 3:27:20 PM

143878

Page 1

Item ID: D350-749-015

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Low to High Gear Conversion

Stop

NS2

Start Date: 3/28/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/8/2016 Req'd Qty: 1.00***1***

Customer:

Reference:

Approvals:

Process Plan: SUDate: 20160324

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-749	D	6 9-89							
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP350-749-015 CHG 001 "NO DART ARC OR C OF C REQUIRED"								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MO 160405

DAS
28
9-89

APR 06 2016

DAS
6
9-89

APR 06 2016

DAS
28
9-89DAS
27
9-89DAS
28
9-89

APR 06 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Work Order ID 143878***143878***

Page 2

Item ID: D350-749-015

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Low to High Gear Conversion

Stop ***NS2***

Start Date: 3/28/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/8/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPPD350-749-015
Location : FG121
PPP Rev: _____
"NO DART ARC OR COPIER REQUIRED"
**ATTN: ALL ORIGINAL EUROCOPTER ARC AND
TAGS TO BE SHIPPED WITH KIT**

DAS
28
9-89

APR 06 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

APR 06 2016

MUS APR 06 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
QC / QA Coordinator Approval									

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Picklist Print

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Work Order ID: 143878

143878

Parent Item: D350-749-015

D350-749-015

Parent Item Name: Low to High Gear Conversion

Start Date: 3/28/2016

Required Date: 4/8/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 08-02-14 DD verified by: LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
350A41-1088-20		Purchased	No			110	Each	8.0000	4	4			
350A41-1088-20									**				
Strip, Chafing, Upper													
	DAS 28 9-89			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					DAS 6 9-89
				ST594		8							
				125114		4							
				m132111		4							
350A41-1090-20		Purchased	No			110	Each	4.0000	2	2			
350A41-1090-20									**				
Strip, Chafing, Lower Front													
	DAS 28 9-89			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					DAS 6 9-89
				ST582		2							
				594 m132111		2							
				t594		2							
				125114		2							
350A41-1089-20		Purchased	No			110	Each	4.0000	2	2			
350A41-1089-20									**				
Strip, Chafing, Lower Rear													
	DAS 28 9-89			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					DAS 6 9-89
				ST582		2							
				m132111		2							
				ST594		2							
				125114		2							

APR 04 2016

Picklist Print

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Work Order ID: 143878

143878

Parent Item: D350-749-015

D350-749-015

Parent Item Name: Low to High Gear Conversion

Start Date: 3/28/2016

Required Date: 4/8/2016

Start Qty: 1.00

Required Qty: 1.00

350A41-1092-22

Purchased

No

110

Each

4.0000

4

4

350A41-1092-22

Half Clamp

DAS
28
9-89

Location

Loc Qty

Loc Code

ST595

4

m129837

4

**

DAS
6
9-89

DAS
27
9-89

22201TK080018X

Purchased

No

110

Each

5.0000

2

2

22201TK080018X

SCREW

DAS
28
9-89

Location

Loc Qty

Loc Code

ST567

5

125114

1

m132111

4

**

DAS
6
9-89

DAS
27
9-89

23112TK080X

Purchased

No

110

Each

2.0000

2

2

23112TK080X

WASHER

DAS
28
9-89

Location

Loc Qty

Loc Code

ST568

2

ST568

125114

1

125172

1

**

DAS
6
9-89

DAS
27
9-89

ASN52320BH120N

Purchased

No

110

Each

8.0000

2

2

ASN52320BH120N

NUT

DAS
28
9-89

Location

Loc Qty

Loc Code

ST550

8

ST550

120055

3

121159

4

125114

1

**

DAS
6
9-89

DAS
27
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Shop Packet Print

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Picklist Print

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Page 3

Work Order ID: 143878

143878

Parent Item: D350-749-015

D350-749-015

Parent Item Name: Low to High Gear Conversion

Start Date: 3/28/2016

Required Date: 4/8/2016

Start Qty: 1.00

Required Qty: 1.00

22201TK060070X

Purchased

No

110

Each

6.0000

2

2

22201TK060070X

SCREW

Location

Loc Qty

Loc Code

ST567

6

125114

2

m132111

4

DAS
28
9.89

DAS
6
9.89

APR 04 2016

DAS
27
9.89

Page 1

[illegible]

DAS
28
9-89

Qty -011	Qty -013	Qty -016	Qty -021	Qty -023	Qty -031	Qty -033	Part Number	Description
X							D350-748-011	LANDING GEAR KIT HIGH, AERAZUR / DART CYLINDRICAL FLOAT COMPATIBLE
	X						D350-748-013	LANDING GEAR KIT HIGH, AIRCRUISER / DART TRI-BAG FLOAT COMPATIBLE
		X					D350-748-015*	STANDARD TO HIGH GEAR CONVERSION KIT
			X				D350-748-021	LANDING GEAR KIT HIGH, AERAZUR / DART CYLINDRICAL FLOAT COMPATIBLE W/ RUN-ON LANDING WEARPLATE
				X			D350-748-023	LANDING GEAR KIT HIGH, AIRCRUISER / DART TRI-BAG FLOAT COMPATIBLE W/ RUN-ON LANDING WEARPLATE
					X		D350-748-031	LANDING GEAR KIT HIGH, AERAZUR / DART CYLINDRICAL FLOAT COMPATIBLE W/ DELUXE SKIDTUBES
						X	D350-748-033	LANDING GEAR KIT HIGH, AIRCRUISER / DART TRI-BAG FLOAT COMPATIBLE W/ DELUXE SKIDTUBES
1	1		1	1	1	1	D350-748-101	CROSSTUBE INSTALLATION, AS 350/355 HIGH FWD
1	1		1	1	1	1	D350-748-201	CROSSTUBE INSTALLATION, AS 350/355 HIGH AFT
1							D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
1							D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
	1						D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRUISER/DART TRI-BAG FLOAT COMPATIBLE
	1						D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRUISER/DART TRI-BAG FLOAT COMPATIBLE
			1				D350-636-015	SKIDTUBE INSTALLATION, LH, STD AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE WITH RUN-ON LANDING WEARPLATE
			1				D350-636-016	SKIDTUBE INSTALLATION, RH, STD AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE WITH RUN-ON LANDING WEARPLATE
				1			D350-636-017	SKIDTUBE INSTALLATION, LH AIRCRUISER/DART TRI-BAG FLOAT COMPATIBLE WITH RUN-ON LANDING WEARPLATE
				1			D350-636-018	SKIDTUBE INSTALLATION, RH AIRCRUISER/DART TRI-BAG FLOAT COMPATIBLE WITH RUN-ON LANDING WEARPLATE
					1		D350-636-215	SKIDTUBE INSTALLATION, LH, STD AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE DELUXE
					1		D350-636-216	SKIDTUBE INSTALLATION, RH, STD AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE DELUXE
						1	D350-636-217	SKIDTUBE INSTALLATION, LH AIRCRUISER/DART TRI-BAG FLOAT COMPATIBLE DELUXE
						1	D350-636-218	SKIDTUBE INSTALLATION, RH AIRCRUISER/DART TRI-BAG FLOAT COMPATIBLE DELUXE
		4					350A41-1088-20	STRIP, CHAFING, UPPER
		2					350A41-1090-20	STRIP, CHAFING, LOWER, FRONT
		2					350A41-1089-20	STRIP, CHAFING, LOWER, REAR
		4					350A41-1092-22	HALF, CLAMP
		2					22201TK080018X	SCREW
		2					23112TK080X	WASHER
		2					ASN52320BH120N	NUT
		2					22201TK060070X	SCREW

*ADDITIONAL PARTS ARE REQUIRED WHEN SWITCHING FROM STANDARD TO HIGH GEAR ON AS350/355 AIRCRAFT. CUSTOMERS WHO ARE SWITCHING FROM STANDARD TO HIGH GEAR CAN PROCURE THE D350-749-015 CONVERSION KIT.

D	ADD -111/-113/-121/-123/-131/-133	CP	15.05.28
C	ADD -021/-023/-031/-033 KITS	RF	11.09.28
B	ADD D350-749-015 KIT FOR STANDARD TO HIGH GEAR CONVERSION	PH	08.02.08
A	NEW ISSUE	CP	08.09.07
REV.	DESCRIPTION	BY	DATE
DESIGN	GP		
DRAWN	RF		
CHECKED	AP		
MFG. APPR.	N/A		
APPROVED	10/9		
DE APPR.	10/9		
DATE	15.05.28		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D350-749	REV. D SHEET 1 OF 2
TITLE LANDING GEAR KITS	SCALE NTS
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